

Date: Tuesday, 10/24/2006 10:54:31 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 29121		
Estimate Number	: 10389		
P.O. Number	: <i>N/A</i>	Part Number	: D31964
This Issue	: 10/24/2006	Drawing Number	: D3196 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: U/R
Previous Run	: 26889	Material	: <i>N/A</i>
	Type : MACHINED PARTS	Due Date	: 11/10/2006
Written By	: <i>[Signature]</i>	Qty:	6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New Issue 05-11-08 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 3.0345 f(s)/Unit Total: 18.2070 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)  
 (M6061T6B0.750x01.500)  
 Identify for D3196-4  
 Batch: *M102447*

*ml 06/10/29*

6

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank: (.075" x 1.50") x 34.750" long Bar

*ml 06/10/29*

6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4

2-Deburr

*ml 06/10/30*

6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/10/30*

6

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*ml 06/10/30 x6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 20 Date: 06/11/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:54:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 29121

Part Number: D31964

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PC 06/11/01  
JL 06/11/01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M19720  
A.M. 06/11/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JB 06/11/09 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST136

JB 06/11/09 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JB 06/11/10

Job Completion



W 06/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29121
<b>Description:</b> Bar		<b>Part Number:</b>	D3196-4
<b>Inspection Dwg:</b> D3196	<b>Rev:</b> XB 06.10.24	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	—			
33.650	+/-0.010	33.650	—			
16.639	+/-0.010	16.639	—			
0.488	+/-0.010	0.488	—			
0.962	+/-0.005	0.963	—			
0.464	+/-0.010	0.462	—			
0.504	+/-0.010	0.502	—			
Ø0.344	+0.005/-0.000	Ø0.345	—			
Ø0.660 x 100°	+/-0.010	Ø0.660x100°	—			
0.512	+/-0.005	0.508	—			
0.060 x 45°	+/-0.010	0.064 x 45°	—			
4.750	+/-0.010	4.750	—			
12.531	+/-0.010	12.531	—			
16.627	+/-0.010	16.627	—			
21.844	+/-0.010	21.844	—			
29.625	+/-0.010	29.625	—			
0.250	+/-0.010	0.250	—			
1.000	+/-0.010	1.000	—			
R0.125	+/-0.010	R0.125	—			
0.987	+/-0.010	0.987	—			

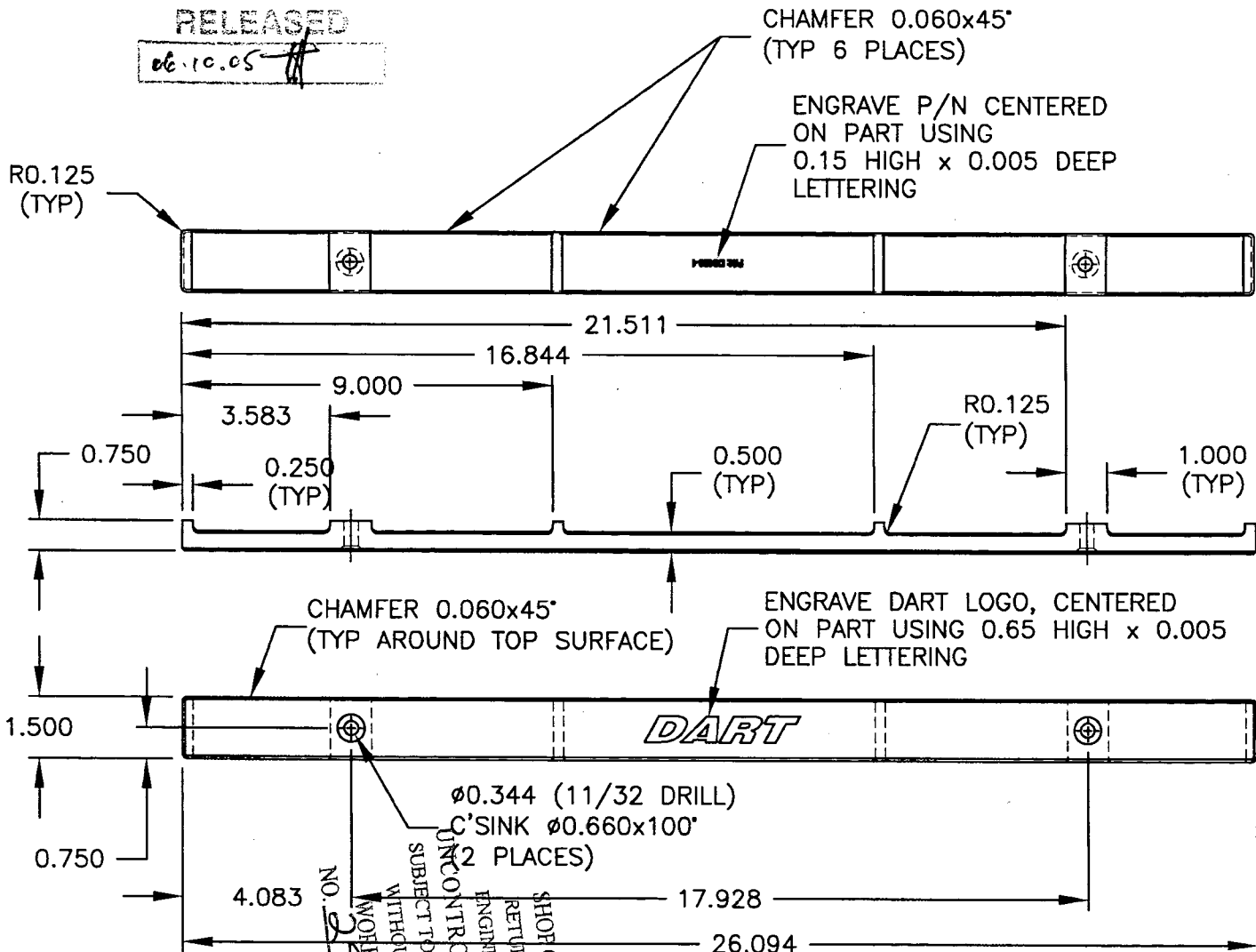
<b>Measured by:</b>	gm	<b>Audited by:</b>	J.L	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/10/30	<b>Date:</b>	06/10/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-017)	KJ/RF	TH

TH

# DART

DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	11	APPROVED	11	DRAWING NO.	REV. E
				D3196	SHEET 1 OF 4
DATE	06.09.25			TITLE	SCALE
				BAR	1:4
A	03.06.25			NEW ISSUE	
B	06.09.25			ADD D3196-5	



**D3196-1 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

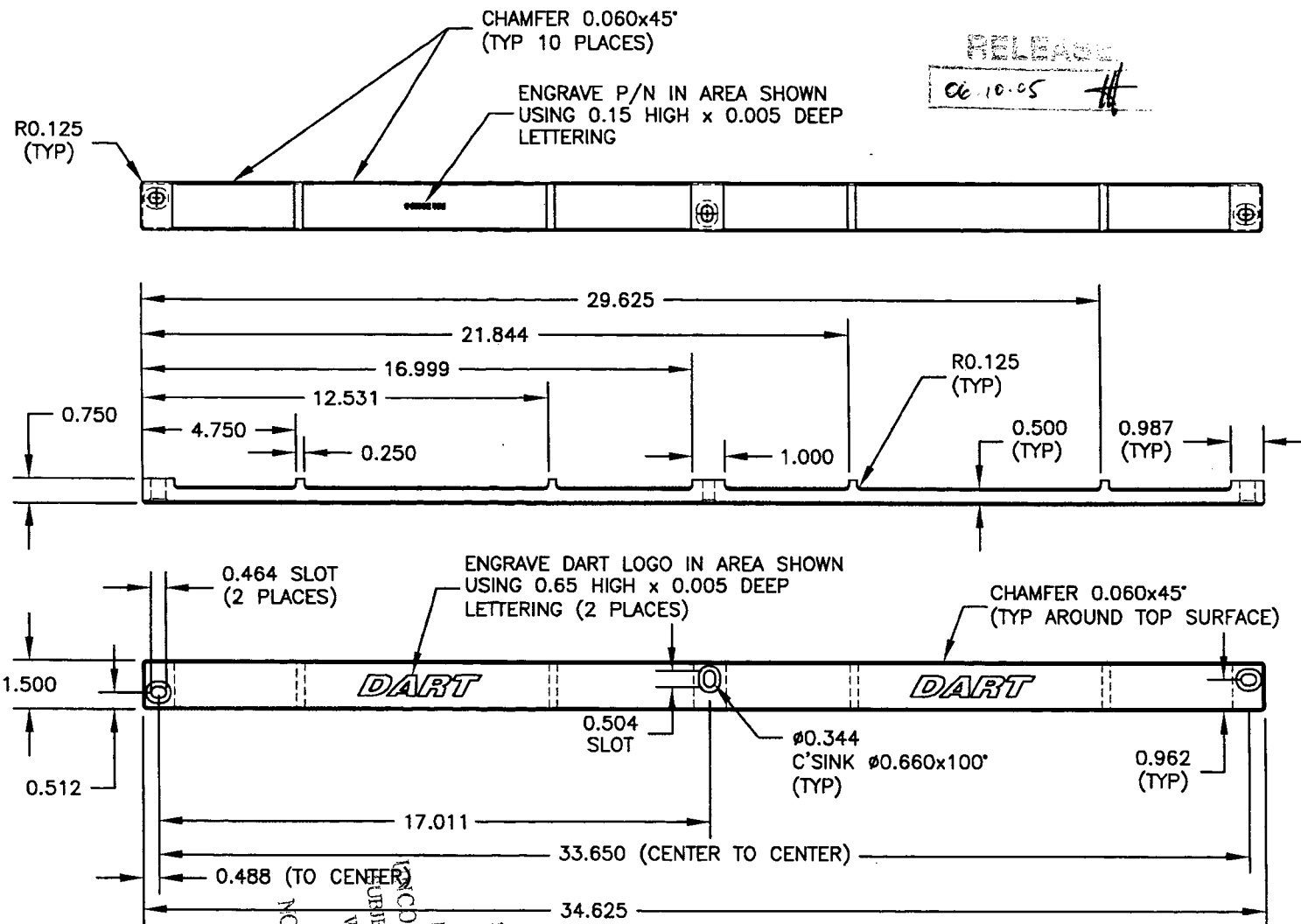
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DATE	06.09.25	TITLE	BAR	REV. B
		DRAWING NO.	D3196	SHEET 2 OF 4
		SCALE	1:5	



### D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

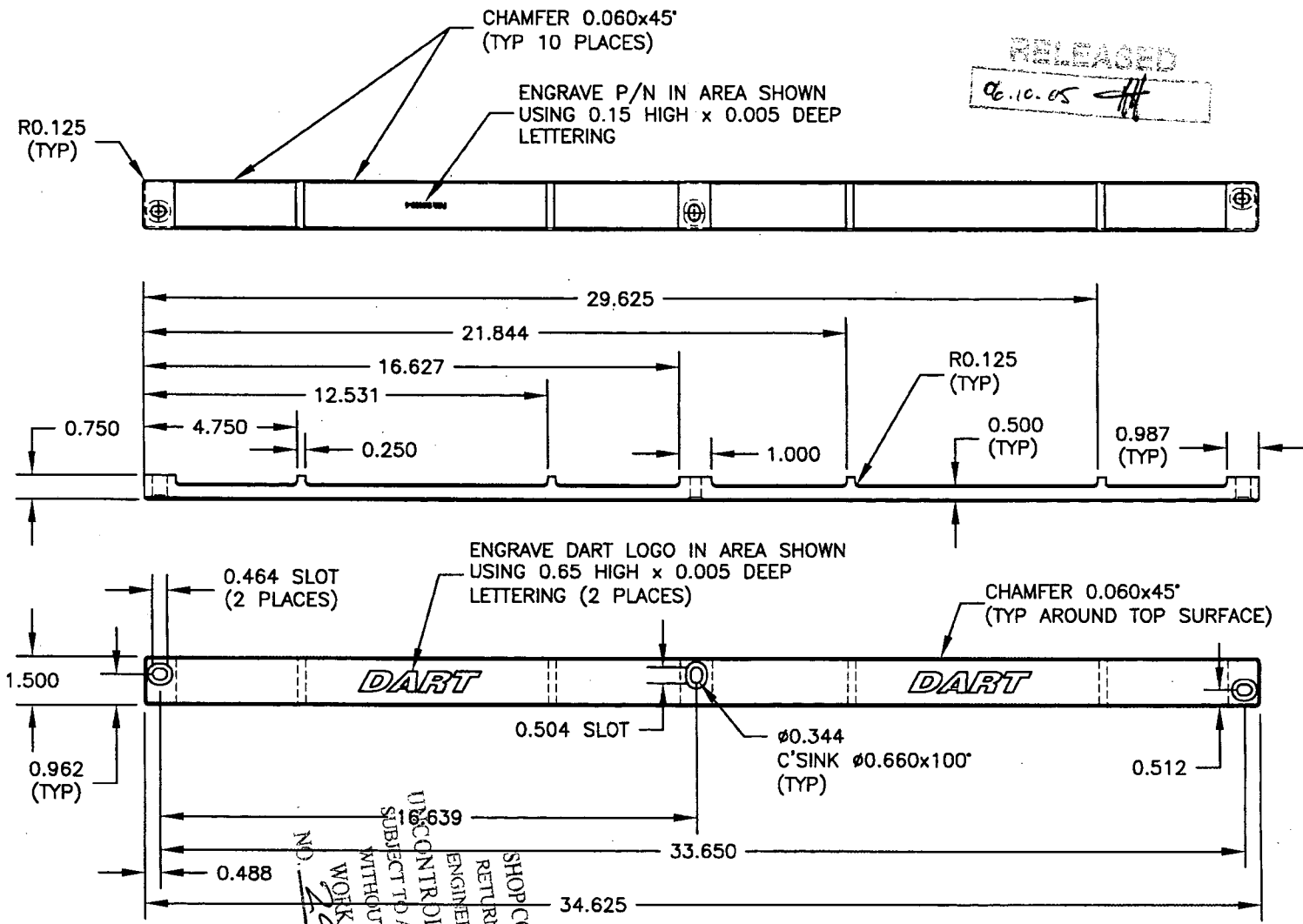
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		TITLE	BAR
		SHEET 3 OF 4	REV. B
		SCALE	1:5



**D3196-4 BAR**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

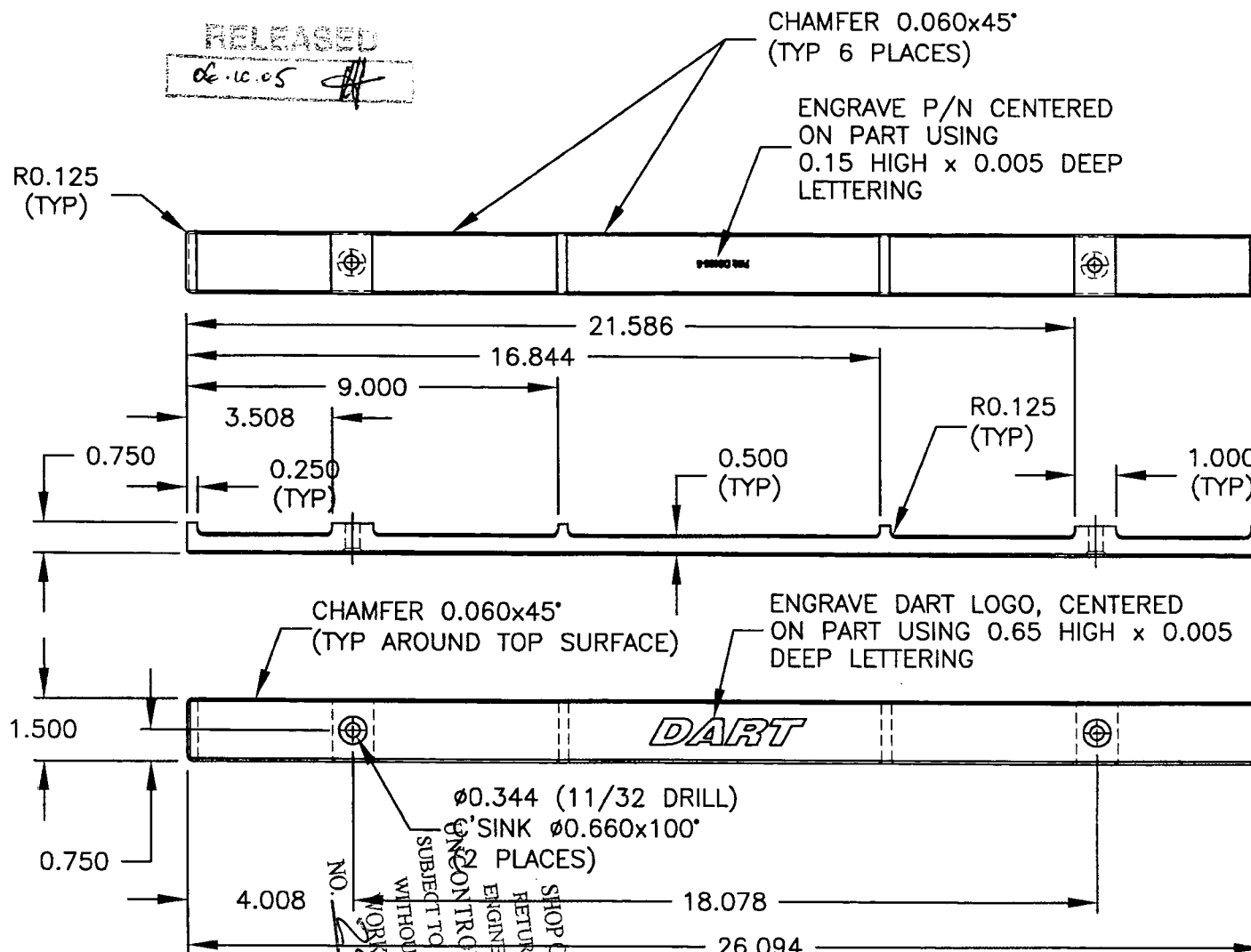
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		TITLE	BAR	SHEET 4 OF 4
				SCALE
				1:4



### D3196-5 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES